

Date: Wednesday, 6/27/2007 1:08:08 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 33212		
Estimate Number	: 11123		
P.O. Number	:	Part Number	: D2460
This Issue	: 6/27/2007 S.O. No. :	Drawing Number	: D2460 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: D
Previous Run	: 31188	Material	:
Written By	:	Due Date	: 7/12/2007 Qty: 4 Um: Each
Checked & Approved By	: <u>Kim Johnston</u>		
Comment	: Est Rev. F Added Finish as per Rev D 05-11-30 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2244116	Step Extrusion
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Comment: Qty.: 0.5000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part #	Description	Batch
.5	D2244	Step Extrusion	<u>B23404</u>

07.10.02 Q-M 4

2.0	D23381	End Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch No.
1	D2338-1	End cap	<u>B34992</u>

08.03.26 4

3.0	D23382	End Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch No.
1	D2338-2	End cap	<u>B34993</u>

08.03.26 4

4.0	D2459	204 Step Lug
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch No.
1	D2459	Lug	<u>B33233</u>

08.03.26 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33212

Part Number: D2460

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 per Dwg. D2460

a.m 07.10.02

(4)

2-Weld per Dwg. D2460

A/R Alum rod

Batch:

*M106834
M106762*

FL 08.03.27 4
FL 08.03.27 4

3-Deburr

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/27 (4)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08.03.27

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/03/27 (4)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M10700 S

M-1 08/03/31 (4X)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk per dwg D2460

Batch:

M107385

FL 08/03/31 (4)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

AS 8/4/1 (4X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33212

Part Number: D2460

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP

B34979

AS 08/04/01

(X)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08 04 02

W

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



umf

08-04-01

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

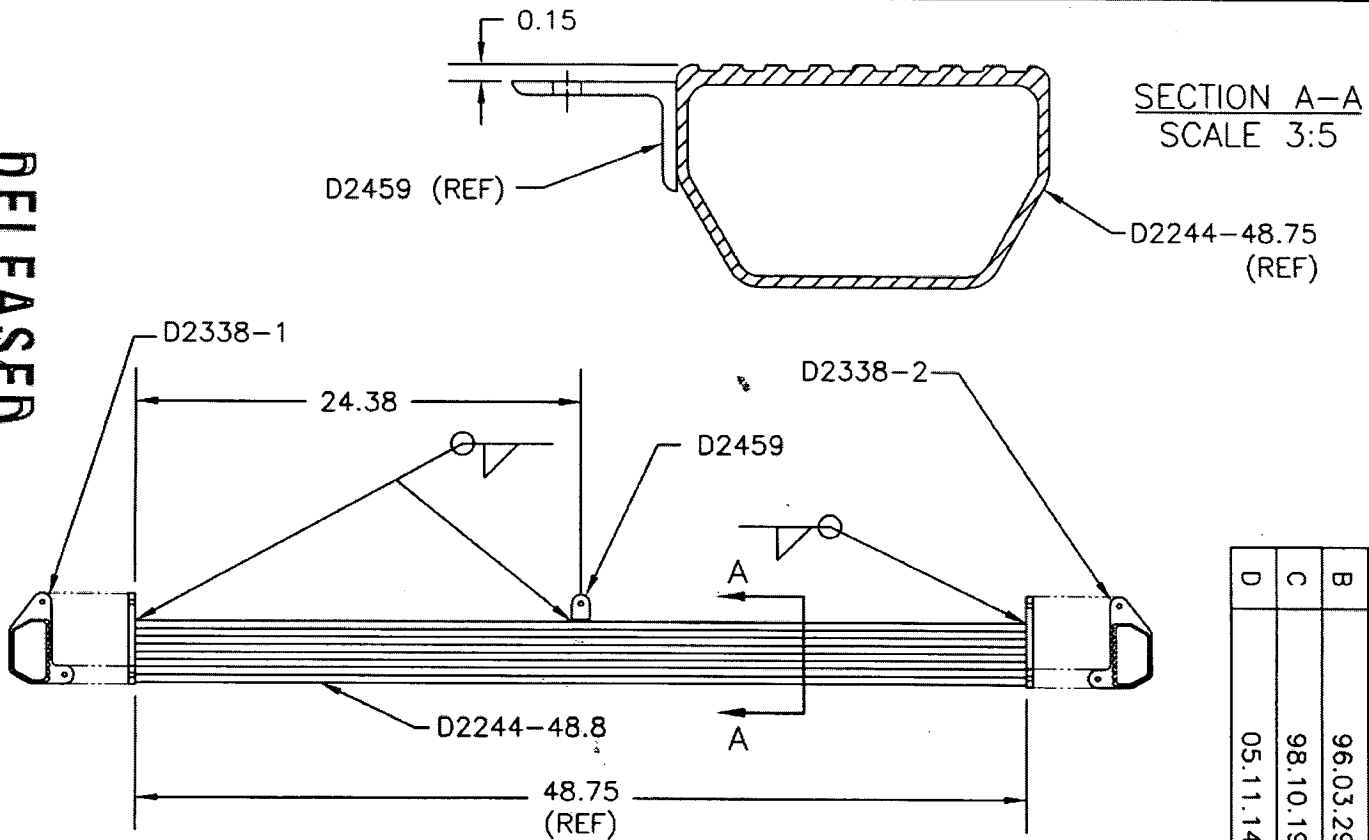
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	BW	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.11.14	DRAWING NO.	D2460	REV. 0
		TITLE	STEP WELDMENT ASSEMBLY	SHEET 1 OF 1
A	95.01.25	NEW ISSUE		SCALE 1:10
B	96.03.29	CHANGE END PLATES		
C	98.10.19	ADDED SECTION A-A (TSR A915)		
D	05.11.14	UPDATE FINISHING NOTES		



D2460 STEP WELDMENT ASSEMBLY PARTS LIST

P/N	DESCRIPTION	QTY
D2460	STEP WELDMENT ASSEMBLY	X
D2244-48.8	EXTRUSION*	1
D2338-1	ENDPLATE	1
D2338-2	ENDPLATE	1
D2459	ANGLE	1

*cut per drawing

D2460 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID TOP SURFACE TO BOTTOM OF
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.28